

17-4 H900 1 3/8"

145666

Work Order ID 144783

144783

Page 1

April 22, 2016 4:27:19 PM

Item ID: D3689-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Sleeve

Start Date: 4/28/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/12/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLS Date: APR 25 2016 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3689

Rev B

100

0.00

100

Doosan

DOOSAN LATHE

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA722 Rev: AA & Dwg D3689 Rev: B
 2-CHECK THREAD WITH GO-NO GO GAUGE DT9450 A & B
 3-Deburr per dwg D3689

DAS

45

9-89

2016-5-19

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

DAS

45

9-89

2016-5-24

120

0.00

120

Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

C'sink .188" holes as per dwg D3689

DAS

45

9-89

2016-5-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

Work Order ID 144783

April 22, 2016 4:27:20 PM

144783

Page 2

Item ID: D3689-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Sleeve
 Start Date: 4/28/2016 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 5/12/2016 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				12	0		DAS 45 9-89 2016-5-24
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT	0.00 0.00				12	0		DAS 49 9-89 16/05/26
150 *150* Purchasing Purchasing	PURCHASING Memo Issue P/O: 32647 LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required	0.00 0.00				12			C216/06/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							DAS 13 9-89
160	Packaging	Memo				12		JUN 29 2016	
Packaging	Ensure certificate of conformity is attached	0.00							
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
170	QC	Memo				(12)			JUN 24 2016
Quality Control									
180	Identify as per dwg & Stock Location:	0.00							
180	Packaging	Memo				12		JUN 28 2016	
Packaging		0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 144783

April 22, 2016 4:27:20 PM

144783

Page 4

Item ID: D3689-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Sleeve

Start Date: 4/28/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/12/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

16/6/29
Lem 16/06/29

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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OTHER : ☐																									

Picklist Print

April 22, 2016 4:27:19 PM

Page 1

Work Order ID: 144783

144783

Parent Item: D3689-1

D3689-1

Parent Item Name: Sleeve

Start Date: 4/28/2016

Required Date: 5/12/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 08-02-11 JLM Verified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC
IPP Rev:C Add note on material cutting JLM Verified By:JM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.375		Purchased		No		100	f	23.7500	0.5	6.31579			

M174PH-H900R1 375

17-4 SS H900 ROUND BAR 1.375

Location

Loc Qty

Loc Code

MAT031

23.75

m126952

11.75

m134368

12

DAS
45 2016-5-24
9-89
~~5,019~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER : ☐					

DART AEROSPACE LTD		Work Order:	144785
Description: Sleeve		Part Number:	D3689-1
Inspection Dwg: D3689	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

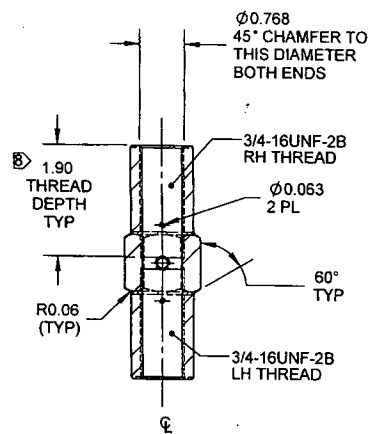
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.90	+/-0.030	1.900	✓		caliper	SPEC
Ø0.768	+/-0.010	0.773	✓		"	"
Ø0.063	+0.005/-0.001	0.063	✓		"	"
R0.06	+/-0.030	r0.04	✓		rad-	Shop
3/4-16UNF-2B	N/A	OK	✓		go ^{+tap} rings	Shop
0.035 x 45°	+/-0.010 x 0.5°	0.035x45°	✓		depth-	SPEC
1.5	+/-0.030	1.490	✓		calipers	SPEC
1.35	+/-0.030	1.352	✓		"	-
Ø0.188	+0.005/-0.001	0.188	✓		"	-
90°	0.5°	90°	✓		Avg.	Shop
Ø0.250	+/-0.010	0.244	✓		Caliper	SPEC
Ø1.075	+0.000/-0.015	1.070	✓		mich.-l	JEC-UZ
1.13	+/-0.030	1.130	✓		Caliper	JEC-OI
4.00	+/-0.030	4.008			"	-
minor Ø	MAX 0.696	>0.690	✓		"	-
3/4-16unf-2B min	0.682				"	-
	DAS		DAS			

Measured by:	45 9-89
Date:	2016-5-24

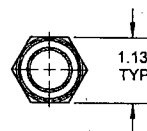
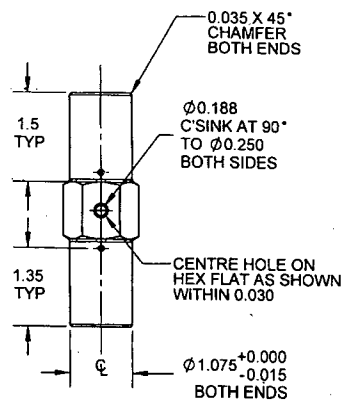
Audited by:	9-89
Date:	16/05/21

Prototype Approval:	N/A
Date:	N/A

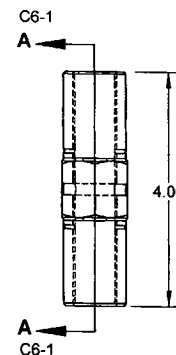
Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	



SECTION A-A
D3-1



D3689-1 SLEEVE



THIS COPY
RETURN TO
ISSUING
CONTROLLED COPY
NOT TO AMENDMENT
NOTICE
WORK ORDER
144783 MJS
16-04-05

RELEASED
08/12/15

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.67 lb
 - 8) DIMENSION SHOWN IS MINIMUM DEPTH OF FULL THREAD
 - 9) LPI PER ASTM 1417 LEVEL 2

B	CHANGE TO 17-4PH H-900 (ZN A8-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	40	DRAWING NO.	REV. B
MFG. APPR.	24	D3689	SHEET 1 OF 1
APPROVED	#	TITLE	SCALE
DE APPR.	#	SLEEVE	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32647**

Purchase Order Date 6/8/2016

PO Print Date 6/16/2016

Page Number 4 of 5

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

					Line Total:	\$123.30
9	145286	D119-796-241 CROSSTUBE	6/8/2016 Yes 6/8/2016	1.00	\$123.30	\$123.30
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2					Line Total:	\$123.30
10	144783	D3689-1 SLEEVE	6/8/2016 Yes 6/8/2016	12.00	\$10.28	\$123.30
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2					Line Total:	\$123.30
11	144592	D3688-1 STUDS	6/8/2016 Yes 6/8/2016	7.00	\$17.61	\$123.30
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2						

C216106116

Note:

6/16/2016



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO28523	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 32647
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 2

Work Required:

CARRY OUT NDT ON 19 PARTS AS PER PO32647

12 SLEEVES, ITEM ID# D3689-1 , WORK ORDER ID# 144783

7 STUDS, ITEM ID# D3688-1 , WORK ORDER ID# 144592

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, UV M-20141, CLEANER SKC-S MPO13923 , DEV. MPO11715						JUN 10 2016	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	
		DAS 38					
		9-89					
		JUN 24 2016					
		N/A					

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		JUN 10 2016